0.00 Memo Quality Control

QC

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	C	Oate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No	:	PAR #:	n: PAR #: Fault Category:					Date: _						
	R	esolution:	Dispositio	n:	_ QA: N/C	Close	ed:	Date: _						
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)								
DATE	STEP	Description of NC	Description of NC Corrective Action				Verification	Approval	Approval					
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Section C	Chief Eng	QC Inspector					
		·												

Work Order ID 77754

Quality Control

77754

Page 2

December-21-11 8:23:50 AM Item ID: D212-664-101TRN Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Crosstube Turning Detail Start Qty: 1.00 **Start Date:** 21/12/2011 **Cust Item ID: Required Date:** 04/01/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Start **Tooling: Approvals:** Process Plan: ____ Date: Date: Stop Date: ____ QC: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID Description Run Hours** Code Qty Qty Number Stamp 120 0.00 MORI SEIKI CNC LATHE LARGE *120* Mori Seiki 0.00 Memo Mori Seiki CNC Lathe Large 1-Turn second side as per Folio FA113 2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit. FOLIO REV: DWG REV: 3-Remove sand and plugs 130 QC1- Inspect dimensions to dimension sheet 0.00 QC 0.00 Memo

mm. 1 1/01/02

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							,		Prod Mgr			
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Part No	:	PAR #:	PAR #: Fault Category:					:	Date:			
	R	esolution:	Disposit	ion:	_ QA: N/0	Clos	sed:		Date: _			
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (N	CR)						
DATE	CTED	Description of NC		Corrective Action Secti			Verifica	ation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section		Chief Eng	QC Inspector		
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Work Orde				*77754*						
Item ID: Revision ID: Item Name:	D212-664-10			Accept	*N900	<u>040100</u>)* :	Setup Start Stop	*NS1* *NS2*	
	21/12/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	ID:			INO	
Approvals:	Process Pla	n:	Date:	Tooling:	D	ate:	I	Run Start	*NR1*	
	QC:		Date:	SPC (Y/N):	D:	ate:		Stop	*NR2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool# Plan Code	Accept Qty		Reject Insp. Number Stamp	
*140 *140*		QC8- Inspect parts - seco	nd check	0.00			/	2-1-	. 3	
QC Quality Control		Memo		0.00						
145				0.00						
145 Crosstubes		Memo		0.00			м.			
Crosstubes			Y TRANSITION LINES	SMOOTH LONGITUDE	WAY.	AT	12	- 1-3		

Crosstubes Chemical Conversion

0.00

150 HandFXtube

Memo

0.00

Hand Finishing Crosstubes

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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					28.7									
Part No: PAR #:			Fault Cat	egory:	_ NCR: Y	es No	DQA:	_ Date: _						
	Resolution:			on:	QA: N/C	Closed	:	Date: _	·					
NCR:			WORK ORE	DER NON-CONFORM	ANCE (N	CR)								
DATE	STEP	Description of NC	Description of NC Corrective Action Description				erification	Approval	Approval					
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector					
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Work Orde				*77754*						
Item ID: Revision ID: Item Name:	D212-664-10			Accept	*N90004010	n * •	Setup Start Stop	*NS1* *NS2*		
Start Date: Required Date: Reference:	21/12/2011 04/01/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:			14.7/		
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Date:Date:	- -	Run Start Stop	*NR1* *NR2*		
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID Tool # Plan Code	~ •		Reject Insp. Tumber Stamp		
¹⁷⁰ *17∩*		Packaging		0.00						
Packaging Packaging		Memo Identify and S Location: <u>(</u>	itock in kanban rack	0.00	An .		m :1			

180 QC21- Final Inspection - Work Order Release 0.00

180
QC Memo 0.00

Quality Control

ex 12/01/04

R12-01-3

W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	CTED	Description of NC		Corrective Action Sec Action Description	tion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	ion Sign & Date			on C	Chief Eng	QC Inspector	
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										3,

Picklist Print

December-21-11 8:23:54 AM

Work Order ID: 77754

77754

Parent Item:

D212-664-101TRN

D212-664-101TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 21/12/2011

Required Date: 04/01/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 08-03-06 new issue DD verified by:ec

IPP Rev B 08.04.02 removed Polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6005-128		Manufactured	No			120	Each	6.0000	1	1			
D6005-13	28								**				

Crosstube Material

Location Loc Qty Loc Code LG

- mon. L 11/12/29

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W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Resolution:		Dispositio	on:	QA: N/C C	osed:		Date: _	·
NCR:		V	WORK ORD	ER NON-CONFORMAN	ICE (NCF	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
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Item	Qty -141	Qty -141B	Part Number	Description
1	Х		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		Х	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

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1) MATERIAL: MANUFACTURED FROM D6005-128

FINISHED LENGTH = 126.514±0.020

2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

-) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664) D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

COPY

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REMOVED FROM LINDER REVIEW PER
UNDER REVIEW SCHILL 11-G14

LINDS 17

LINDS 17

LINDS 17

LINDS 26

LINDS 26

LINDS 26

LINDS 27

LINDS 26

LINDS 2

DEO ATTACHED

RELEASED 2009 -10 -2 9

REFORMAT/REVISE GENERAL NOTES/PART LIST: 09.09.30 REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4 REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 07 03 08 6398, CUSHION, REVERSE CLAMPS ADD HOLES FOR COMPATABILITY WITH BHT/AA 05.02.04 SKIDTUBES Α NEW ISSUE РН 00.12.12 REV. DESCRIPTION DATE DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. D MFG, APPR. D212-664-141 SHEET 1 OF 4 APPROVED TITLE SCALE DE APPR. XTUBE ASSY (205/212/412 HI FWD) NTS COPYRIGHT © 2000 BY DART AEROSPACE LTD DATE 09.09.30

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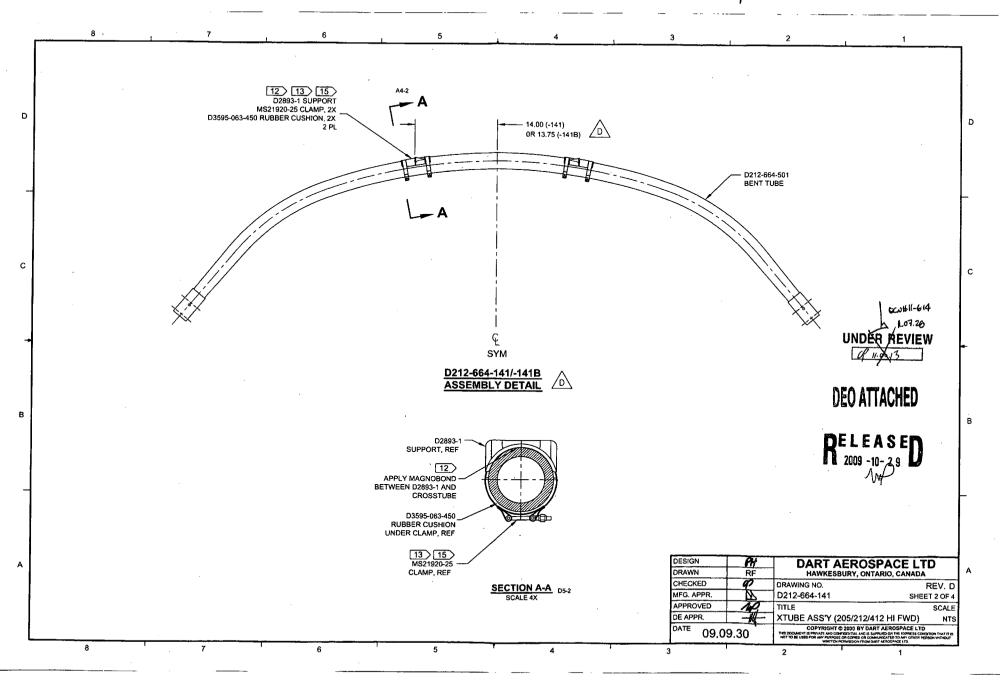
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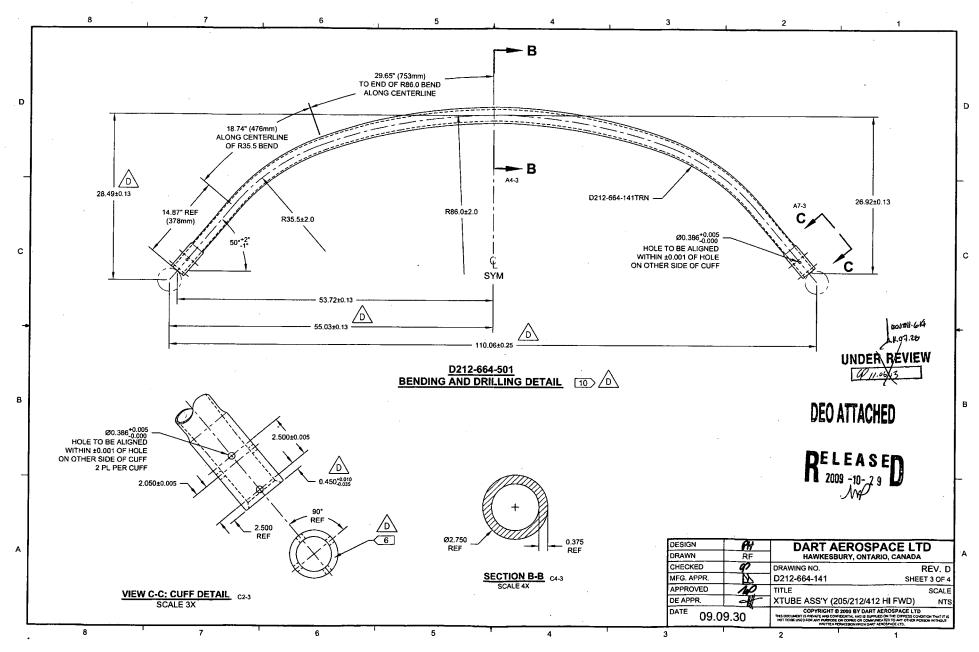
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W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	ANGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No		PAR #:	Fault Cate	egory:	_ NCR:	Yes N	lo DQ	A:	_ Date: _					
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NCR:		1	WORK ORE	ER NON-CONFORMA	ANCE (NCR)								
DATE	STEP	Description of NC			ion B		Verific	ation	Approval	Approval				
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector				
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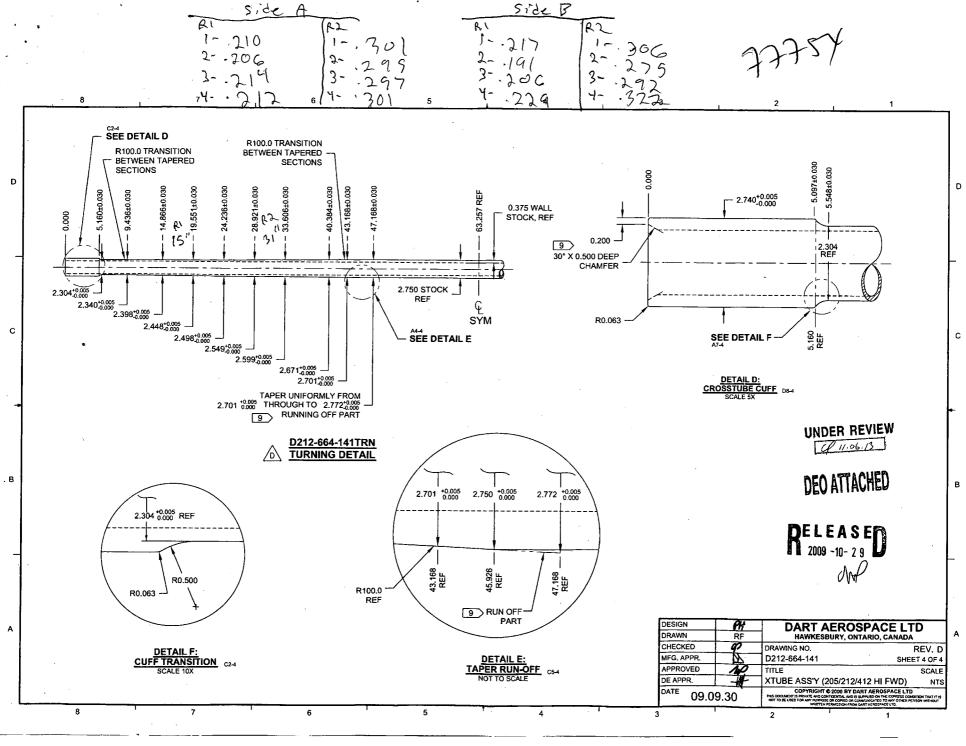


W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _						
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NCR:			WORK ORD	NCE (NCR	3)								
DATE	STEP	Description of NC Section A		Corrective Action Secti		Verification	Approval	Approval					
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
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W/O:		WORK ORDER CHANGES												
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NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NC	R)								
DATE	STEP	TEP Description of NC			on B		cation	Approval	Approval					
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W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DC	A:	Date: _		
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC	<u> </u>	Corrective Action Section		Verif	ication	Approval	Approval	
DAIL	JILF	Section A Init	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Chief Eng	QC Inspector	
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DRAWING NO.	TITLE		REV. D	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D212-664-141	XTUBE ASS	SY (205/212/412 H	I FWD)	ENGINEERING ORDER	D212-664-141-D-1	SHEET 1 OF 2	NTS
DRAWN		CHECKED	P	MFG. APPR. (2	APPROVED NA,	DE APPR	
DATE 11.0	04.07	DATE	1), 64, 11	DATE ((.04.(2	DATE 11/54/12	DATE 11.04.12	

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

<u> 15:</u>

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND

PAINT OUTSIDE PER DART QSI 005 4.2 REMOVE MASKING AND APPLY CLEAR COAT

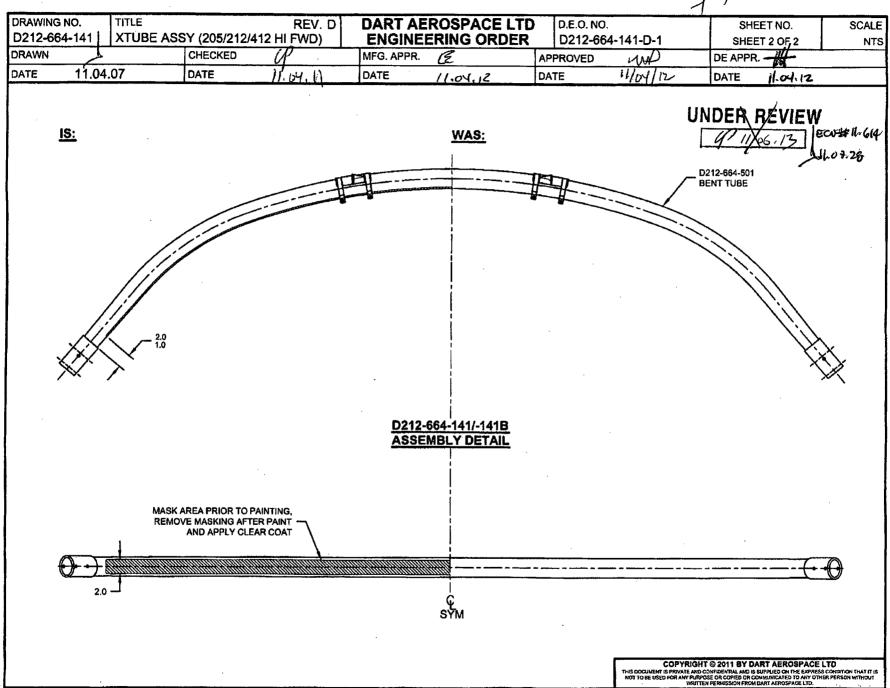
WAS:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

PAINT OUTSIDE PER DART QSI 005 4.2

W/O:			W	ORK ORDER CHANG	ES						
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR:	ICR: Yes No DQA: D				Date:	
	R	esolution:	Dispositi	on:	QA: N/C Closed: Date:						
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DATE	CTED	Description of NC		Corrective Action Secti			Verific	Verification Approval Approva			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector	
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W/O:			WC	RK ORDER CHANG	ES					
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NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	l)				
DATE	STEP Description of NC Section A	Description of NC		on B	Verific		Approval	Approval		
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DRAWING NO. TITLE DART AEROSPACE LTD REV. D D.E.O. NO. SHEET NO. SCALE CROSSTUBE ASS'Y (205 HI FWD) D212-664-141 **ENGINEERING ORDER** D212-664-141-D-2 SHEET 1 OF 1 NTS DRAWN CHECKED A>S MFG. APPR APPROVED DE APPR. 11.07.15 11.07.20 DATE DATE 11/07/21 DATE 11.07.21 DATE DATE 11.07.21

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL

CHANGE:

IS:

item	Qty -141	Qty -141B	Part Number	Description
7	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

İ					
ı	7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023
					ADHESIVE (TEXTRON/BELL SPEC. 299-947-100,
					TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

19.

- 12) TO INSTALL D2893-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



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WITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES									
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	R	Resolution:	Disposit	ion:	- 1	Q <i>A</i>	: N/C CI	osed:		_ Date:	
NCR:			WORK OR								
		Description of NC		· · · · · · · · · · · · · · · · · · ·	ve Action	Section B		Verificat	Verification Approval App		
DATE	STEP	Section A	Initial Chief Eng	Act	tion Descrip Chief Eng	otion	Sign & Date	Section (Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	27754
Description: Crosstube Assembly (205/212/412 High Fwd)	Part Number:	D212-664-141
Inspection Dwg: D212-664-141 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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	spection Sheet	Tolerance	Actual	Accept	Reject	Method of	
Dra	awing Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
	0.200	+/-0.010	200			vers	C4 CL04
	R0.063	+/-0.010	.063	\checkmark	<u> </u>	26	
	2.740	+0.005/-0.000	2.743			vern	CW 6-06
	5.097	+/-0.030	5.095	/		1	
	2.304	+0.005/-0.000	2.309				
4	2.340	+0.005/-0.000	2,345				
	2.398	+0.005/-0.000	2-403				
SIDE	2.448	+0.005/-0.000	2.453	<i>\(\sigma_i \)</i>			
	2.498	+0.005/-0.000	2,500				
	2.549	+0.005/-0.000	2-554				
	2.599	+0.005/-0.000	2-603				
	2.671	+0.005/-0.000	2-67-1	>			
	2.701	+0.005/-0.000	2-703	V		4	
	0.200	+/-0.010	ر مرکز ہ	J		vern	CNC-05
	R0.063	+/-0.010	067			RG	
	2.740	+0.005/-0.000	7,741			Vern	CNILOL
	5.097	+/-0.030	5.695)	
] [2.304	+0.005/-0.000	2304				
_	2.340	+0.005/-0.000	2.345				
E B	2.398	+0.005/-0.000	2.403				
SIDE	2.448	+0.005/-0.000	2,453				
	2.498	+0.005/-0.000	2.501				
	2.549	+0.005/-0.000	7-564				
	2.599	+0.005/-0.000	2-604				
	2.671	+0.005/-0.000	2.674				
	2.701	+0.005/-0.000	2-703			V	
	126.514	+/-0.020	126.520			Fupe	MAN-L-OZ

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Measured by: mgm cl	Audited by:	Prototype Approval:	N/A
Date: 12/01/02	Date: 12-1-3	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
В	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
С	07.05.28	Dwg Rev updated	KJ/JLM	
D	10.02.02	Dimension 126.514 was 126.51	KJ de	X
				

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Part No:		esolution:	PAR #:	Fault Category:			s No DQ /		
NCD.		10th	W	ORK ORDER NO	N-CONFORM	ANCE (NC	(R)		

NCR:		· , W	ORK ORD	ER NON-CONFORMANC	E (NCR)			
DATE	STEP	TEP Description of NC Section A		Corrective Action Section B	Verification	Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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